

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020112**Date Inspected:** 09-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Fluxed Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ming Yang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3014-C

Weld No: 061, 065, 069, 073, 077, 081

Welder: 201583

WPS-B-T-2233 ESAB

Amps: 263

Volts: 26.2

PCMK: DP-3123-001

Weld No: 019, 020, 043, 044, 075, 076

Welder: 048696

WPS-B-T-2132-ESAB

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Amps: 306

Volts: 26

PCMK: DP-3123-001

Weld No: 045, 050, 085, 090, 107, 114

Welder: 048433

WPS-B-T-2233-ESAB

Amps: 265

Volts: 26.3

PCMK: DP-3146-001

Weld No: 241, 245

B-CWR: 2403, 2404

Welder: 045240

WPS-345-FCAW-2G(2F)-Repair-ESAB

Amps: 310

Volts: 26.4

PCMK: DP-3146-001

Weld No: 251, 254

B-CWR: 2405, 2406

Welder: 202122

WPS-345-FCAW-2G(2F)-Repair-ESAB

Amps: 301

Volts: 26.3

PCMK: DP-3146-001

Weld No: 257, 259

B-CWR: 2407, 2408

Welder: 045143

WPS-345-FCAW-2G(2F)-Repair-ESAB

Amps: 305

Volts: 26.3

PCMK: DP-3148-001

Weld No: 241, 245, 248

B-CWR: 2414, 2415, 1416

Welder: 045280

WPS-345-FCAW-2G(2F)-Repair-ESAB

Amps: 310

Volts: 26.2

PCMK: DP-3148-001

Weld No: 251, 254, 257

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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B-CWR: 1417, 1418, 1419

Welder: 047866

WPS-345-FCAW-2G(2F)-Repair-ESAB

Amps: 307

Volts: 26.3

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Photos please see ; Z:\Inspector Reports\B314 Rice

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Rice,Brett	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
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